



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23007615-9
Job Sheet 196827



Part No: RB23007615-9

Job Qty: 10 pcs

Part Name: #22 Drill Bit



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/21/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time		
110	SL-154 - 1	10 pcs	7/5/19	7/5/19	1.00	3.33	SL-154 - 1		MSP 19/08/07
120	QC 2	10 pcs	7/5/19	7/5/19	0.00	0.00	QC 2 - 1		
Container No: S204171  Part: RB23007615 - 9 Job No: 196827 Serial No/Batch: S204171 Revision: B Inspector: Exp Date: Instructions: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/09/19					QC 2 - 12				
					QC 2 - 14				
					QC 2 - 17				
					QC 2 - 19				
					QC 2 - 2				
					QC 2 - 20				
					QC 2 - 22				
					QC 2 - 23				
					QC 2 - 25				
					QC 2 - 32				
					QC 2 - 33		MSP 19/08/07		
					QC 2 - 35				
					QC 2 - 39				
					QC 2 - 4				
					QC 2 - 40				
					QC 2 - 44				
					QC 2 - 45				
					QC 2 - 48				
					QC 2 - 49				
					QC 2 - 50				
					QC 2 - 51				
					QC 2 - 52				
					QC 2 - 57				
					QC 2 - 62				
					QC 2 - 63				
					QC 2 - 8				
					QC 2 - 66				
					QC 2 - 64				
QC 2 - 65									

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Container No: S204171



Part: RB23007615-9

Job No: 196827

Serial No/Batch: S204171

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/09/19

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130 QC 8	10 pcs	7/5/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.P 19-08-15
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Outsource - 4 - Anodize	10 pcs	7/5/19		ATG001-VC GR00020	2019-08-19
142 Packaging 2-1 - Receive - B4B	10 pcs	7/5/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
144	QC 6	10 pcs	7/5/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
146	Small Fab - 2 - B4B	10 pcs	7/5/19	0.00 0.50	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	MCC
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
148	QC 5	10 pcs	7/5/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	DAS
					QC 5 - 30	40
					QC 5 - 40	AUG 29 2019 9-89
180	Packaging 3-1 - Stock - B4B	10 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
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					Packaging 3 - 21 - B4B	
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					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	7/5/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

AUG 30 2019

Part Op 110 - (MORI SL-154 LATHE), 1-Machine (-2 block) as per folio FC031 FOLIO REV: AA DWG REV:

Descriptions: B 2- Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB), 1- Engrave drill sizes using Marktronic engraver as per DWG RB23007615 sheet #2.

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1), -Issue P/O; PO 44287 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

142 - (Receive & Inspect for Damage & Mat'l Certs)

144 - (QC6- All purchased or subcontracted products)

146 - 1- Assemble #22 drill bit into RB23007615-2 with Loctite clear multipurpose.

148 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6H0.312	6061-T6 Hex Bar .312	.9000 ft (.09 ea)	110-SL-154 - 1	<u>5162400</u>
AC40122	No. 22 Us 118 Pol Hs Job Drill	10 Ea (1 ea)	146-Small Fab - 2 - B4B	<u>4x 5088967</u> <u>2x 516278</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M6061T6H0.312	1	24	0
146-Small Fab - 2 - B4B	AC40122	10	22	0

Part Specifications

Specifications could not be found.

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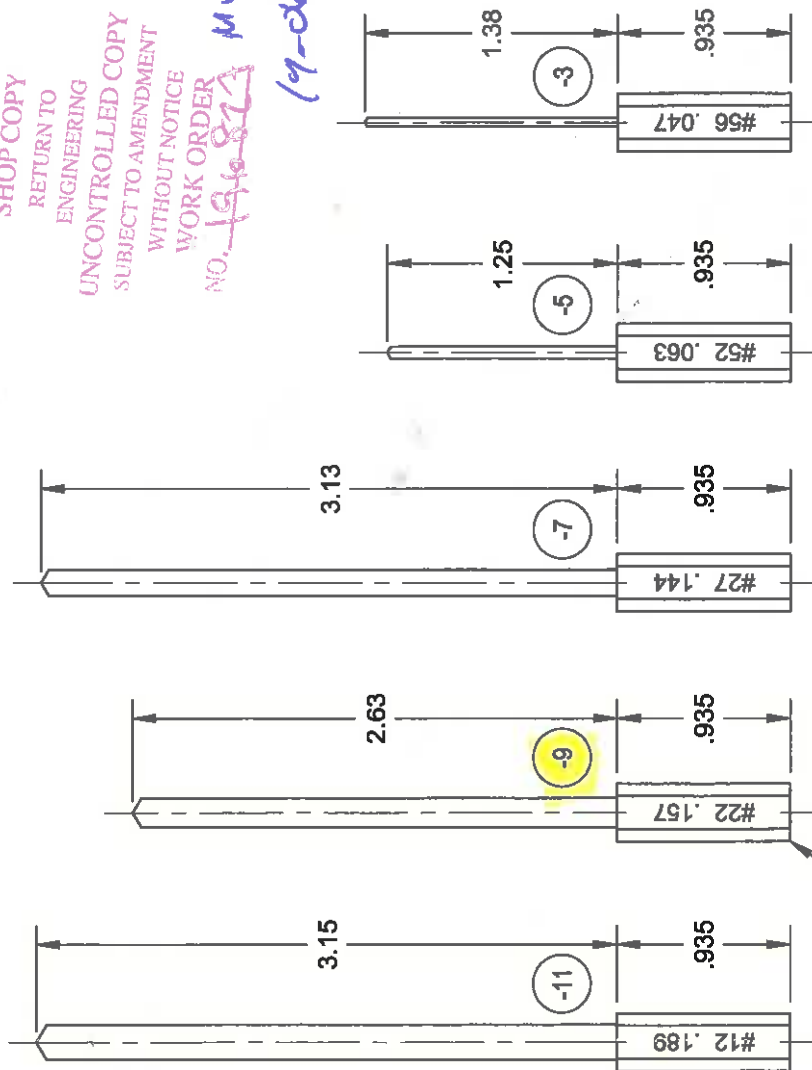
This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	-2 ADDED NOTES TO SHEET.	2/3/14	DPD
			RJC

TEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1940827 MWS

19-06-24



NOTES:

1. CHECK EACH HOLE FOR PROPER EXPOSED DRILL LENGTH.
2. -2 TO BE DRILLED FOR BIT TO ACHIEVE EXPOSED DRILL LENGTH.
3. EPOXY BIT INTO -2 AFTER ANODIZING.
4. ANODIZE BLACK MIL-A-8625F, TYPE II, CLASS II

2 4 5X -2

TITLE		DRAWN BY:	
POWER TURBINE CLEANING KIT		COLE	
DWG NO.		REV	
RB23007615-2 THRU -11		B	
UNLESS OTHERWISE SPECIFIED		APPROVED	
DIMENSIONS ARE IN INCHES		DATE	
TOLERANCES ON:		FINISH	
XX ± .005		SPEC	
XX ± .01		SEE NOTE 4	
X ± .1		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED		ALLISON C30	
1. BREAK ALL SHARP EDGES			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE		SHEET	
1:1		2 of 7	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS				MRB (QSD42)			
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition		Completed By			
Description Work Order Deviation		Rework Scrap Use-as-is		Cross tube Small Fab Finishing Skid-tube Machining Large Fab				Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		FAULT CATEGORY							
				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044287**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044287

PO Date: 8/19/19

Due Date: 8/27/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196827	RB23007615-9	#22 Drill Bit (Outsource process- Anodize per QSI017 4.1.10.1), -Issue PO -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/27/19	10 pcs	0 pcs	10 pcs	\$4.00/pcs	\$40.00
2	198332	C3-8-5	Solenoid Cover -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/27/19	20 pcs	0 pcs	20 pcs	\$4.00/pcs	\$80.00

Grand Total: \$120.00

Handwritten signature and initials



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PURCHASE ORDER

POHB044287



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/20/19 4:26 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021665-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021665 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Aug-2019		Jigar Patel		POHB044287				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RB23007615-9 Rev.	RB23007615-9 ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0

DAS
61
9-89

RECEIVED
 AUG 21 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.